Each

Dart Aerospace Ltd. Wednesday, 6/20/2007 11:21:36 AM User: **Process Sheet Drawing Name** : AFT CROSSTUBE : CU-DAR001 Dart Helicopters Services Customer Job Number : 33028 **Estimate Number** : 10377 : D2890 **Part Number** P.O. Number · D2890 REV B S.O. No. : **Drawing Number** : 6/20/2007 This Issue : N/A Project Number : NC Prsht Rev. : B : PURCHASED PARTS **Drawing Revision** First Issue : // Type : 33027 Material Previous Run Qty: 1 Um: Due Date : 6/27/2007 Written By Checked & Approved By Removed Bending procedures KJ/JLM : Est. 05.03.21 Comment **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: Crosstube extrusion 1.0 D6008180 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Batch Part # Description Qty EL 7-8-15 D6008-180 Crosstube extrusion 25667 BENDING MACHINE 20 BENDING Comment: BENDING MACHINE 1-Bend D2890 as per Dwg D2890 and Folio FT002 3.0 QC6 DIMENSIONAL CHECK Comment: DIMENSI ANDING GEAR RESOURCE 1 LANDING GEA 4.0 Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

## **Dart Aerospace Ltd**

W/O:			WORK ORDER CHANGES					
DATE	STEP	F	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	- <u> </u>	PAR #:	Fault Category:	NCR: Ye	s No DO	Δ.	Date: _	<u> </u>
					N/C Close			

NCR: WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC Corrective Action Section B		Description of NC	Corrective Action Section B		Verification	Ammanal	A =======
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

Wednesday, 6/20/2007 11:21:37 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: AFT CROSSTUBE Customer: CU-DAR001 Dart Helicopters Services Part Number: D2890 Job Number: 33028 Job Number: Description: Seq. #: Machine Or Operation: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 07.08.17 Comment: FINAL INSPECTION/W/O RELEASE Job Completion U 7.08.17

## **Dart Aerospace Ltd**

W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del></del>							
Part No	:	PAR #: Fault Category:	NCR: Ye	s No DQ	٩:	Date: _	

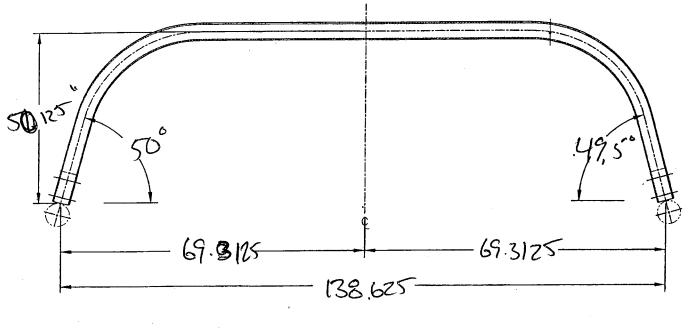
QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:	R: WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section E	3′	Verification	Approval Chief Eng	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector

NOTE: Date & initial all entries

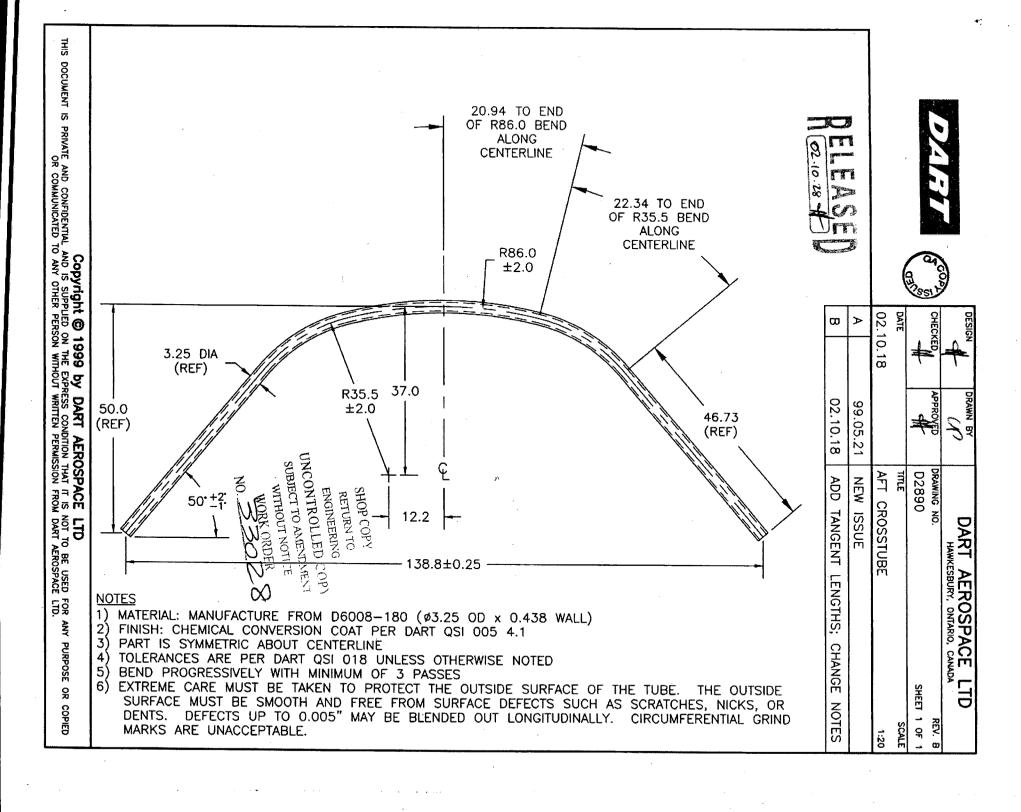
DART AEROSPACE LTD	Work Order:	33028
Description: Crosstube Aft	Part Number:	D2890
Inspection Dwg: D2890 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



	Comments	
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QC15 Inspection	er,	ł
Date	<del>- ~ / ~ / // ~</del>	

Rev	Date	Change	Revised by	Apprøved
Α	07.02.06	New Issue	KJ/JM 🚓	/r~
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DESIGN 4	O DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	DRAWING NO.	REV. A
9	4	D6008	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.17		CROSSTUBE MATERIAL	1:1
Α	00.11.17	NEW ISSUE	

RETURN TO

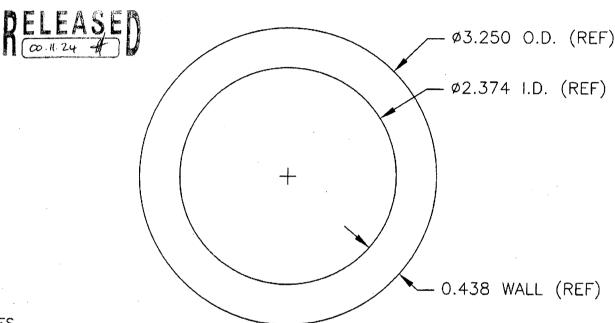
ENGINEERING

UNCONTROLLED COP' SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

## SPECIFICATION CONTROL DRAWING



## **NOTES**

1) D6008-XXX CROSSTUBE LENGTH

WHERE XXX IS LENGTH IN INCHES EG. 180" LONG TUBE: D6008-180

2) MATERIAL: 3.250 OD × 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ- $\frac{44.00}{2}$ 25/9 OR

QQ-A-200/11) SEAMLESS ALUMINUM TUBE. MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi

MINIMUM YIELD TENSILE STRENGTH = 66 ksi

3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:

O.D.:  $\pm$  0.008 MEAN ( $\pm$ 0.016 INCLUDING OVALITY) WALL: ±0.020 MEAN (±0.044 INCLUDING ECCENTRICITY) LENGTH: XXX +0.125/-0.000

STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE,

5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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